

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Withdrawn)
2. (Withdrawn)
3. (Withdrawn)
4. (Withdrawn)
5. (Withdrawn)
6. (Withdrawn)
7. (Withdrawn)
8. (Withdrawn)
9. (Withdrawn)
10. (Currently Amended) A method of manufacturing an easy open can end member comprising the steps of:

providing a can end shell having a public side and an opposing product side, the can end shell including a center panel disposed about a longitudinal axis, a generally U-shaped countersink, an annular arcuate chuck wall, and a curl defining an outer perimeter of the can end shell, the generally U-shaped countersink joining the chuck wall with the center panel;

providing upper and lower tooling for reforming the can end shell;

supporting the can end shell between the upper and lower tooling;

providing relative movement between the can end shell and the upper and lower tooling to reform the can end shell;

moving the center panel downwardly by said providing relative movement step wherein the U-shaped countersink is removed extending an area of the center panel radially outwardly; and

moving the annular arcuate chuck wall downwardly by said providing relative movement step to form a folded portion between the annular arcuate chuck wall and the center panel.

11. (Original) The method of Claim 10 wherein said upper tooling includes first and second forming members, the first forming member positioned radially inwardly from the second

forming member, and said providing relative movement step comprises contacting the public side of the center panel with the first forming member and contacting the annular arcuate chuck wall with the second forming member.

12. (Original) The method of Claim 11 wherein the lower tooling comprises inner, intermediate, and outer forming members, the inner forming member located radially inwardly from the intermediate forming segment, and the intermediate forming segment located radially inwardly from the outer forming member, and said providing relative movement step further comprises contacting the product side of the center panel with the inner forming member, contacting the U-shaped countersink with the intermediate forming member, and contacting the product side of the annular arcuate chuck wall with the outer forming.

13. (Original) The method of Claim 12 wherein said providing relative movement step further comprises forcing the first forming member downwardly while supporting the U-shaped countersink and the annular arcuate chuck wall.

14. (Original) The method of Claim 13 wherein said providing relative movement step further comprises forcing the second and outer forming members downwardly to form the folded portion.

15. (Original) The method of Claim 14 wherein said supporting the can end shell between the upper and lower tooling includes supporting a lower portion of the chuck wall against a portion of the outer tooling member.

16. (Original) The method of Claim 15 wherein said moving the annular arcuate chuck wall downwardly includes moving the annular arcuate chuck wall radially outwardly by said providing relative movement step.

17. (Cancelled)

18. (Withdrawn)

19. (Withdrawn)

20. (Withdrawn)